

Work Order ID 61458

Wednesday, August 25, 2010 2:31:54 PM

BLUE



Page 1

Item ID: D206-642-441

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 8/27/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/24/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: mfDate: 10-8-25

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2650

Rev F

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

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Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R ☐ Aluminum Rod ☒ m114877 / m112507

4-Grind weld flush to cap on top surface only.

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

BE 10/08/27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

115



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S0106127

Memo

0.00

116



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

S0106127

Memo

0.00

④

120



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

DP

10-8-30

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

x1 - BE 08/08/30

W/O:		WORK ORDER CHANGES					
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Start Date: 8/27/2010 Start Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Skidtubes	0.00				1	-		BE 10/03/30
Skidtubes	Memc	0.00							
Skidtubes	1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid)								
	2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)								
	3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.								
	4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting								
	<input type="checkbox"/> Start Date: 10/02/30 <input type="checkbox"/>								
	Time: <input type="checkbox"/> 7:11:00								
	<input type="checkbox"/> Finish Date: 10/01/21 <input type="checkbox"/>								
	Time: <input type="checkbox"/> 8:10 AM								
	A/R <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> m116114 <input type="checkbox"/>								
	Sikaflex expiry date: <input type="checkbox"/> 01/2011								

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/10/08/31

Memo

0.00

50

160



Skidtubes

Skidtubes

Skidtubes

0.00

Memo

0.00

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
A/R Aluminum Rod M112507

2-Grind welds flush as per Dwg D2650.

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Deburr

BE 10/09/07
BE 10/09/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Accept

[illegible]**Setup Start**

Stop

Cust Item ID:[illegible]

Customer:

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID

Tool #**Plan
Code**

Accept Qty

Reject
QtyReject
Number

Insp. Stamp

170

0.00

HandFinishing

0.00

Skidtubes

Memo

Skidtubes

Install D2680-041 Nut Plate as per Dwg D2650

180

0.00

[illegible]

QC10- Inspect visual per QSI004- ground welds

0.00

QC

Memo

Quality Control

190

0.00

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item ID: D206-642-441

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Start Date: 8/27/2010 Start Qty: 1.00

Required Date: 9/24/2010 Req'd Qty: 1.00




Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start _____
Stop _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200  HandFinish	Pressure Wash per QSI005 4.3	0.00				1	0		
Hand Finishing	Memo ✓ Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.	0.00							
205  SprayPaint		0.00							
Spray Painting	Memo Spray paint Delfleet Blue Primer B <u>114424</u> Delfleet Blue B <u>113171</u> Clear Delfleet B <u>115506</u>	0.00							
206  QC	QC14- Inspect Spray Paint	0.00							
Quality Control	Memo	0.00							

ml 10 09 23 (1)

ST 10-09-24 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 HandFinish Hand Finishing	HandFinishing Memo 1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. ✓ A/R <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> M1114093 Sikaflex expiry date: <input type="checkbox"/> 10/10 ✓ 2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive ✓ 3-Install MS27039-4-06 Screw as per DEO 9153 4-Inspect for foreign object per QSI 024 5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive ✓ A/R <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> M1114093 Sikaflex expiry date: <input type="checkbox"/> 10/10 ✓ 6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4 Batch: M115028	0.00 0.00	2211	10/09/28		✓	✓		

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
250 Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D206-642-441 Location: _____ PPP Rev: _____	0.00 0.00							
260 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

10/09/28

10/09/28

10/09/28

10 - 925

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, August 25, 2010 2:31:54 PM

Page 1

Work Order ID: 61458

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube





Start Date: 8/27/2010

Required Date: 9/24/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM
IPP Rev:I 08-05-01 add QC3 DD verified by:EC
IPP Rev:J 08-09-29 revF as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2620  Skidtube, 206 Skidtube		Manufactured	No			110	Each	4.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>4</div> <div></div> </div>													
<div> <div>57542</div> <div>4</div> <div></div> </div>													
D2646  Aft Cap		Manufactured	No			110	Each	72.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>FP-4</div> <div>63</div> <div></div> </div>													
<div> <div>57332</div> <div>63</div> <div>13 61752</div> </div>													
<div> <div>FP6</div> <div>9</div> <div></div> </div>													
<div> <div>52663</div> <div>9</div> <div></div> </div>													
D2647  Cap		Manufactured	No			140	Each	72.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>FP</div> <div>72</div> <div></div> </div>													
<div> <div>55352</div> <div>72</div> <div></div> </div>													
D2654-7  Web		Manufactured	No			160	Each	3.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>3</div> <div></div> </div>													
<div> <div>61264</div> <div>3</div> <div></div> </div>													

861455

①

BE 10/08/27

W/O:		WORK ORDER CHANGES					
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Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 8/27/2010

Required Date: 9/24/2010

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased

No

170

Each

472.0000

2

2



Cherry Rivet



Location

Loc Qty

Loc Code

ST311

472

112314

4

113539

44

113973

424

D2649

Manufactured

No

170

Each

29.0000

23

23



Cross Bolt Spacer



Location

Loc Qty

Loc Code

LG

29

58545

2

60652

27

D2680-041

Manufactured

No

170

Each

35.0000

1

1



Nut Plate



Location

Loc Qty

Loc Code

ST021

35

55366

35

2 BE 10/09/08

261496 (x23) BE 10/09/07

1 BE 10/09/08

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Shop Packet Print

Page 2

Dart Aerospace Ltd

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Parent Item Name: Replacement Skidtube

Start Date: 8/27/2010

Required Date: 9/24/2010

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130 Purchased No

230

Each

3,222.000

60

60



Insert



yl 10/09/28

Location

Loc Qty

Loc Code

PKG11

3030

114723

3030

ST282

153

X60

110511

10

114407

143

ST381

39

114654

39

* AN960JD10L NAS1149D0332J Purchased No

230

Each

2,501.000

62

62



Washer



yl 10/09/28

Location

Loc Qty

Loc Code

ST348

2501

110985

x2

PTO =>

110985

2501

AN960JD416 NAS1149D0463J Purchased No

230

Each

0.0000

1

1



Washer

NAS1149D0463J

1115622



x1 yl 10/09/28

CR3212-4-03 Purchased No

230

Each

1,912.000

2

2



Cherry Rivet



Location

Loc Qty

Loc Code

ST311

1912

111359

5

112314

2

114436

448

114450

83

114859

1374

2

BE 10/09/08

W/O:		WORK ORDER CHANGES					
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Dart Aerospace Ltd

WORK ORDER CHANGES

N/O: 01458					By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP	PROCEDURE CHANGE							
10/09/27	230	USE NAS1149 C0332R Qty (60) FOR WEARSHOES BA 1115698 Qty x Rem chg (need to update IDW)				10/09/28	x60	10/09/27 B1142	10/09/28
10/09/27	230	USE MS-270391C1-040 Qty (60) FOR WEARSHOES N/A				10/09/27		10/09/27 051 042	

Part No: D206-642-441 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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WORK ORDER NON-CONFORMANCE (NCR)

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

Picklist Print

Wednesday, August 25, 2010 2:31:54 PM

Page 4

Work Order ID: 61458

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 8/27/2010

Required Date: 9/24/2010

Start Qty: 1.00

Required Qty: 1.00

D2651-1

Manufactured No

230

Each

734.0000

22

22



Plug



10/09/28

Location

Loc Qty

Loc Code

FP

152

51530

152

fpa

582

53349

411

57869

171

22

D2651-3

Manufactured No

230

Each

342.0000

22

22



O-Ring



10/09/28

Location

Loc Qty

Loc Code

FP

342

46114

342

22

D3535-15

Manufactured No

230

Each

20.0000

1

1



Wearshoe



10/09/28

Location

Loc Qty

Loc Code

FP18

20

59236

7

61241

13

22

D3535-23

Manufactured No

230

Each

7.0000

1

1



Wearshoe



10/09/28

Location

Loc Qty

Loc Code

FP21

7

60864

7

B61830

22

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Page 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 25, 2010 2:31:54 PM

Work Order ID: 61458

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 8/27/2010

Required Date: 9/24/2010

Start Qty: 1.00

Required Qty: 1.00

D3535-37

Manufactured No

230

Each

17.0000

1

1



Wearshoe



10/09/28

Location

Loc Qty

Loc Code

FP

17

51654

4

56101

13

10/09/28

D3536-15

Manufactured No

230

Each

22.0000

1

1



Gasket



10/09/28

Location

Loc Qty

Loc Code

FF

16

56055

4

60875

12

10/09/28

FP11

6

59238

6

D3536-23

Manufactured No

230

Each

10.0000

1

1



Gasket



10/09/28

Location

Loc Qty

Loc Code

FP011

10

60234

10

10/09/28

D3536-37

Manufactured No

230

Each

15.0000

1

1



Gasket



10/09/28

Location

Loc Qty

Loc Code

FP

15

56102

15

10/09/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 61458



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 8/27/2010

Required Date: 9/24/2010

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

32.0000

6

6



Wearpad



10/09/28

Location

Loc Qty

Loc Code

FP

1

55465

1

FP017

48

FP17

31

57713

3

60192

3

60491

25

B61640

X6

D3537-3

Manufactured No

230

Each

10.0000

1

1



Wearpad



10/09/28

Location

Loc Qty

Loc Code

FP19

10

59711

10

B60866

X1

MS27039-1-08

Purchased No

230

Each

1,685.000

2

2



Screw



10/09/25

Location

Loc Qty

Loc Code

ST291

1685

110835

493

114718

192

115108

1000

X2

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 61458

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 8/27/2010

Required Date: 9/24/2010

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

230

Each

118.0000

1

1



Screw



10/09/28

Location

Loc Qty

Loc Code

ST292

118

109061

24

115460

94

XL

MS27039C1-08

Purchased

No

230

Each

802.0000

60

60



SCREW



10/09/28

Location

Loc Qty

Loc Code

FP

801

115336

801

ST293

1

19185

1

X60

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG CW D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW, INCORP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

#61458

RELEASED
08-07-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

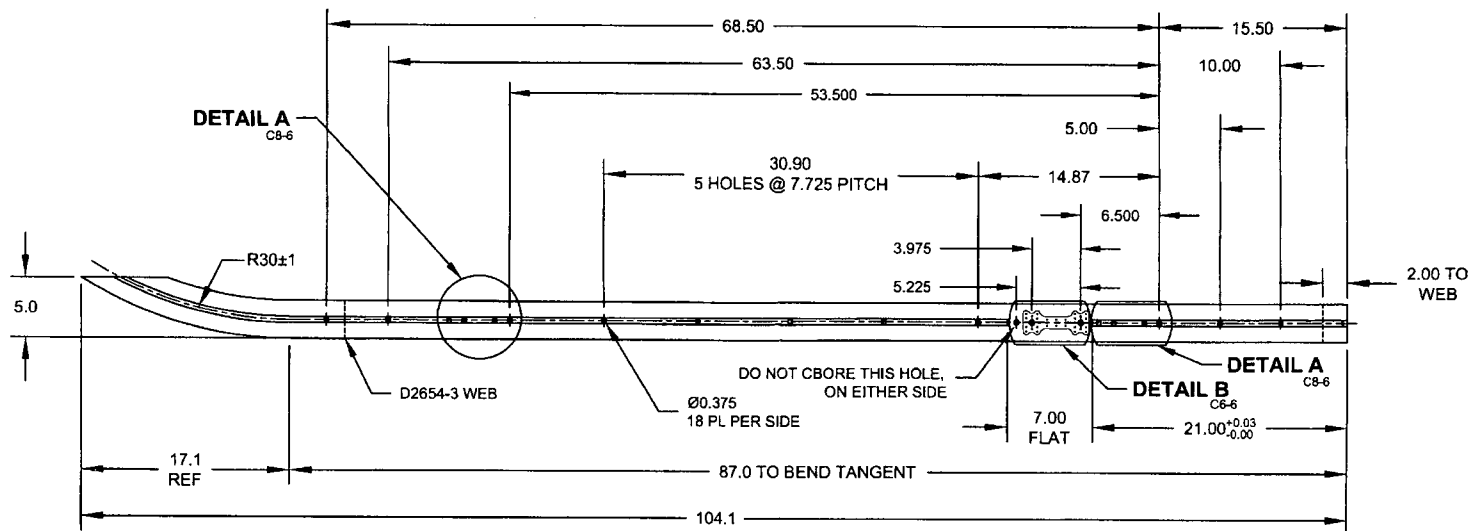
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

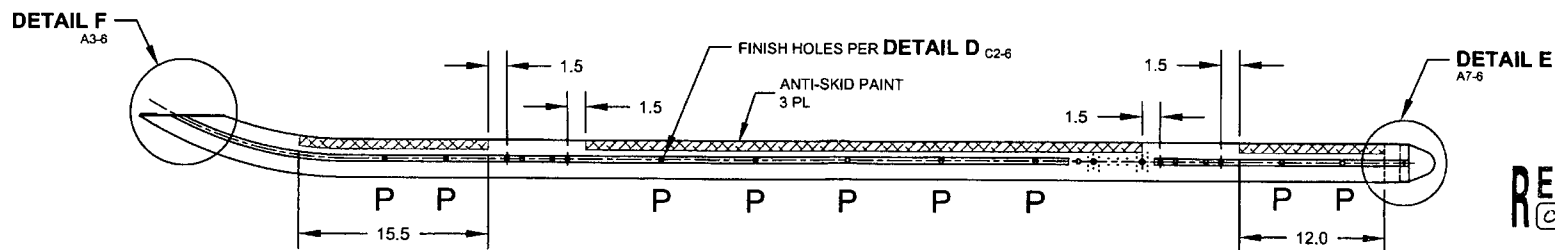
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2650-3 BENDING/DRILLING DETAIL



D2650-3 ASSEMBLY/FINISHING DETAIL

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08 07 22 118

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DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
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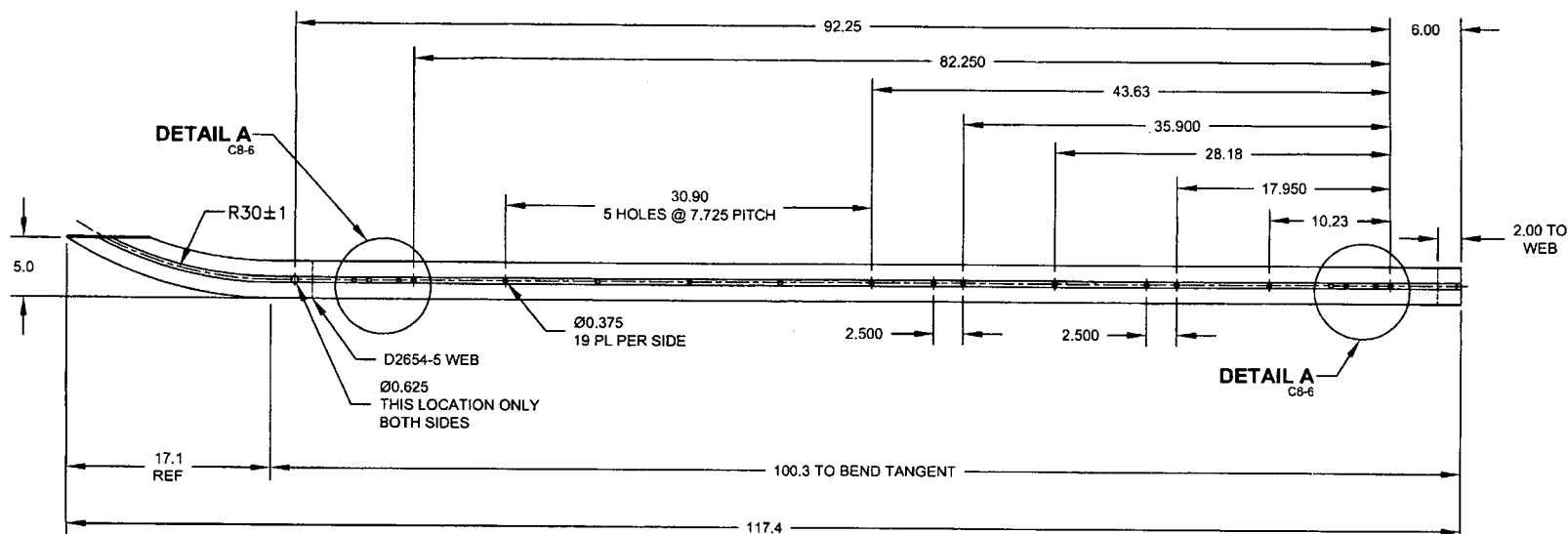
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

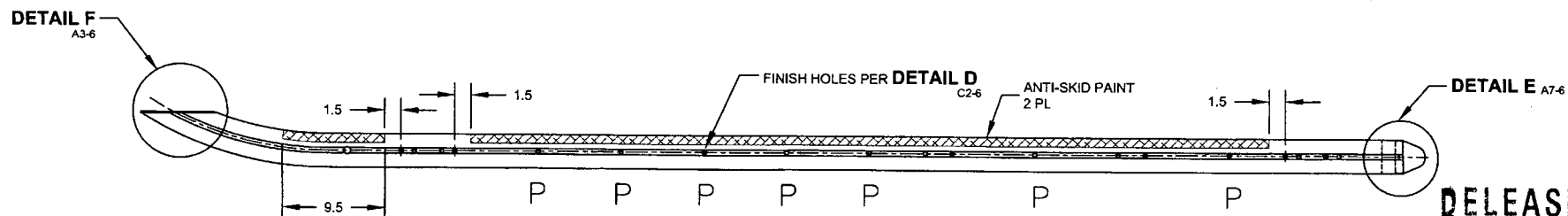
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2650-5 BENDING/DRILLING DETAIL



D2650-5 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
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61458

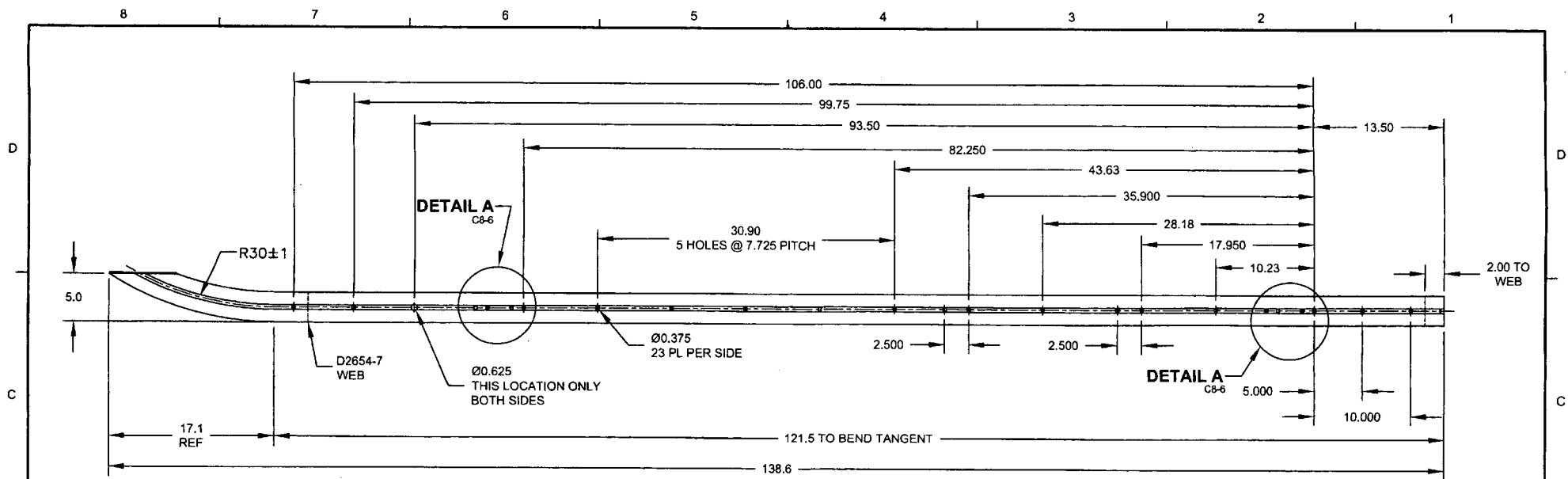
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

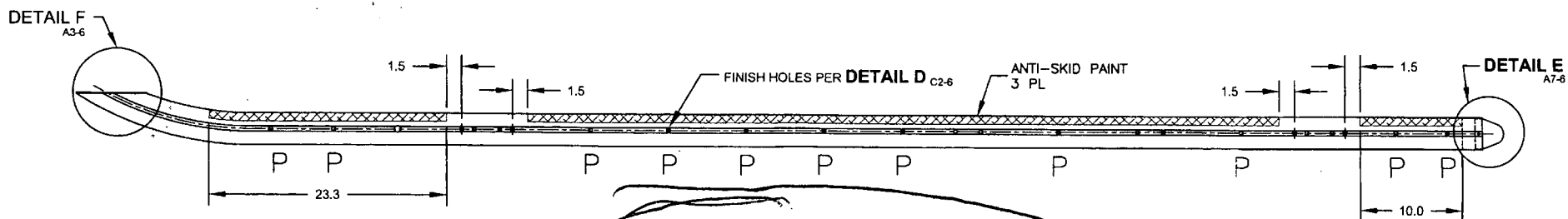
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2650-7 BENDING/DRILL DETAIL



D2650-7 ASSEMBLY/FINISHING DETAIL

#61458

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MFG. APPR.		D2650	SHEET 5 OF 6
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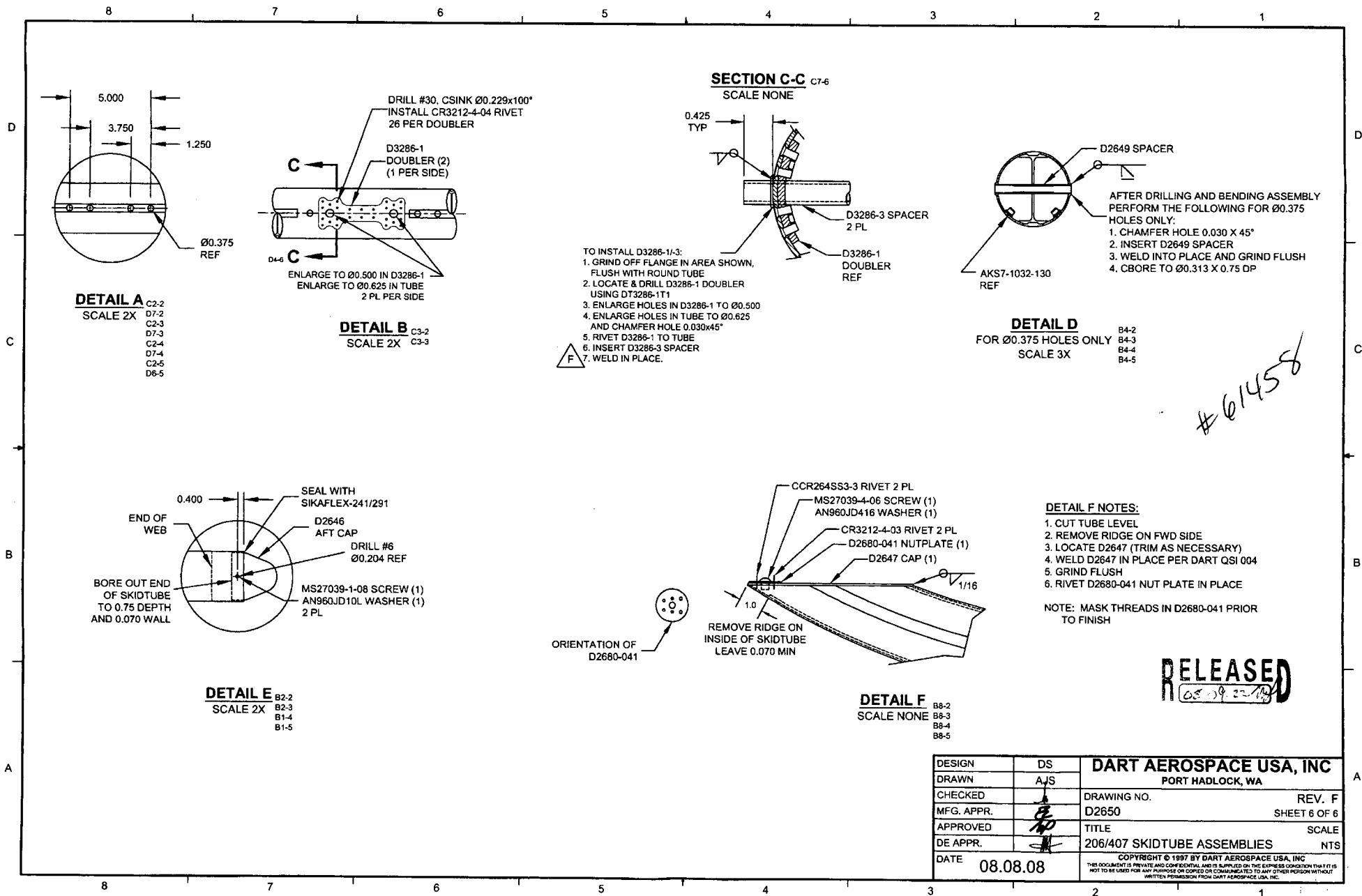
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & Initial all entries

NO. 231

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 61039
Part number: D206-H42-441
Description: 206 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pet Dyl Date of Test Coupon 10.08.19

Welder Barclay Elliott Date of Test Coupon 10.08.19

The above named individual is qualified in accordance with AWS D17.1.2001 to weld